

**Work Order ID 110086**

December-17-13 9:07:52 AM

**\*110086\***

Page 1

Item ID: D2010-104

Revision ID:

Item Name: ARM

Start Date: 12/17/13 Start Qty: 6.00

Required Date: 12/17/13 Req'd Qty: 6.00

Reference:

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: 13-12-19

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run

Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2010

Rev D

100

0.00

**\*100\***

Brake NC

Brake NC

NC BRAKE

Memo

Punch per Dwg. D2010-104 and Spec Control Dwg D2727  
Identify as D2010-104

0.00

110

0.00

**\*110\***

Small Fab

Small Fab

Small Fab

Memo

1- Bend as per Dwg D2010 using bending Jig D2010-104T2  
2- Deburr ends

0.00

120

0.00

**\*120\***

Small Fab

Small Fab

Small Fab

Memo

1- flare before installing plug as per dwg D2010  
2- Install D2057 plug as per Dwg D2010

0.00

86 FF 14-03-1086 FF 14-03-106 FF 14-03-10

# Work Order ID 110086

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**\*110086\***

Page 2

Item ID: D2010-104

Revision ID:

Item Name: ARM

Start Date: 12/17/13 Start Qty: 6.00 **\*6\***

Required Date: 12/17/13 Req'd Qty: 6.00 **\*6\***

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

Quality Control

0.00

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

**\*140\***

Powdercoat

Powder Coating

Memo

START TIME: 2:00

OVEN TEMPERATURE: 320°

FINISH TIME: 2:30

0.00

150

QC3- Inspect Part Finish

0.00

**\*150\***

QC

Memo

Quality Control

0.00

DAS 34 989

**Work Order ID 110086**

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**\*110086\***

Page 3

Item ID: D2010-104

Revision ID:

Item Name: ARM

Start Date: 12/17/13 Start Qty: 6.00 **\*6\***Required Date: 12/17/13 Req'd Qty: 6.00 **\*6\***

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg &amp; Stock Location

**ST 220**

0.00

**(5x)****\*160\***

Packaging

Memo

**1x PPP 113790**

0.00

Packaging

**6x****8****14-03-20**

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

**MLJ 14-03-20****MLJ 14-03-20**

# Picklist Print

December-17-13 9:07:52 AM

Page 1

Work Order ID: 110086  
Parent Item: D2010-104  
Parent Item Name: ARM

Start Date: 12/17/13 Required Date: 12/17/13  
Start Qty: 6.00 Required Qty: 6.00

Comments: IPP A04.02.17New issueKJ/JLM  
IPP Rev:B 08-05-27 as per ECN1195P DD verified by:EC  
IPP Rev:C 08-06-20 rev.D as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TR0.500W.049 304 RD Tube .500 x .049W		Purchased	No			100	f	194.4591	1.5	9.4736844			
--	--	-----------	----	--	--	-----	---	----------	-----	-----------	--	--	--

Location	Loc Qty	Loc Code
MAT017 127937	194.459116	
119087	0.000016	
120633	43.66	
123449	84.0547	
125513	24.534	
m126466	42.2104	

9.473  
~~12.051~~

FF 14-03-18

D2057  
Plug

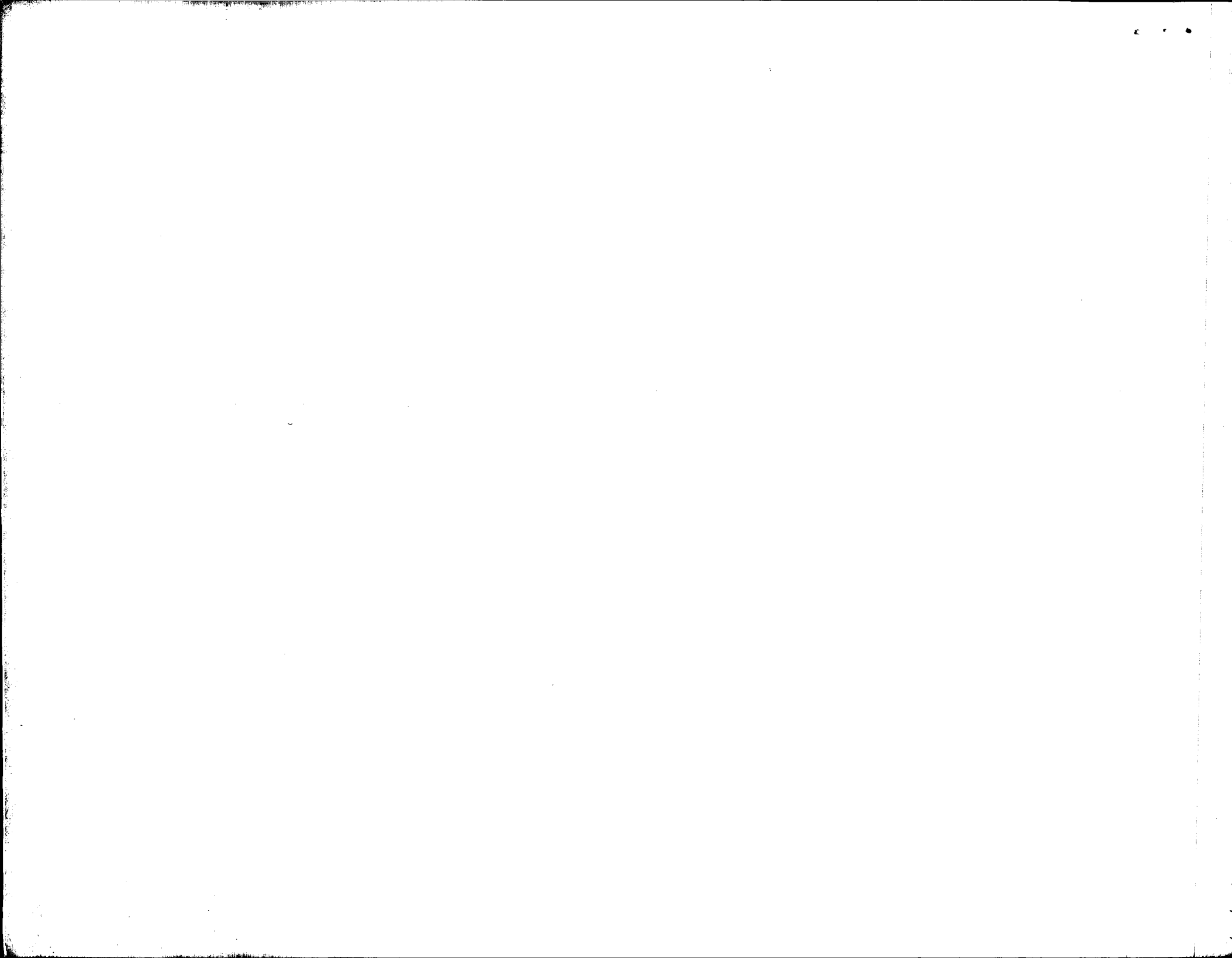
Manufactured No

110 Each 60.0000 1 6

Location	Loc Qty	Loc Code
GA	20	
75070	1	
97932	19	
ST004	40	
105455	39	
71888	1	

6

FF 14-03-18



8

7

6

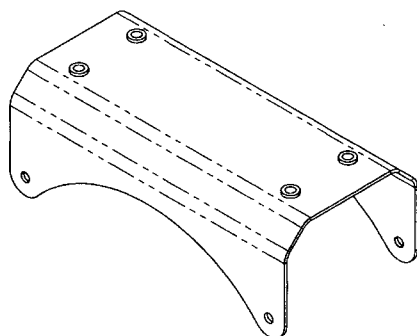
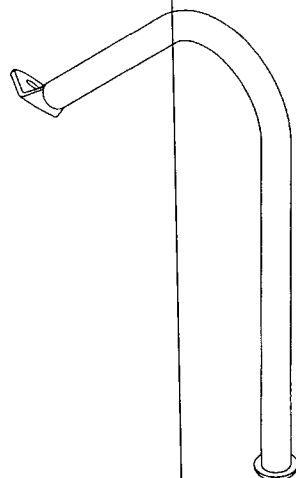
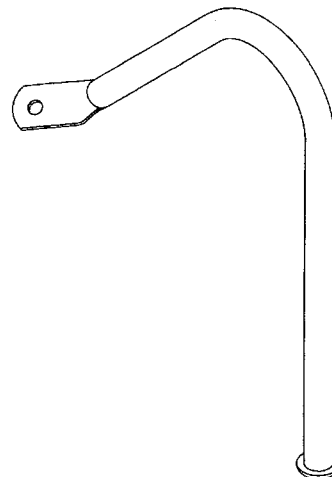
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4

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1

**D2010-101 MIRROR BRACKET****D2010-103 ARM****D2010-104 ARM**

110086 MJS  
13-12-19

RELEASED  
08.06.10

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS: Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON: TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D2010</b> REV. D SHEET 1 OF 4 TITLE <b>MIRROR BRACKET</b> SCALE NTS COPYRIGHT © 1990 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JB		
CHECKED	JB		
MFG. APPR.	JB		
APPROVED	JB		
DE APPR.	JB		
DATE	08.06.10		

8

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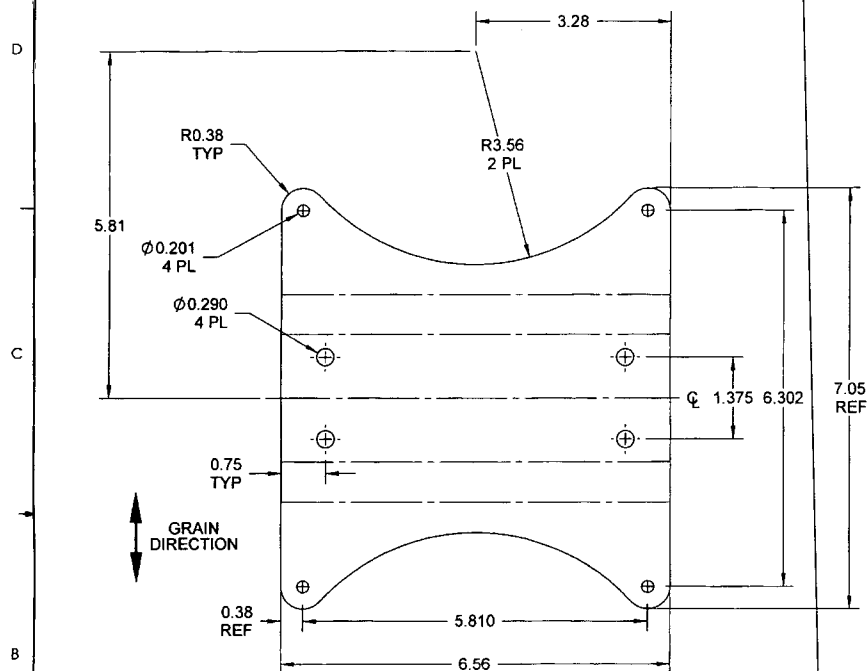
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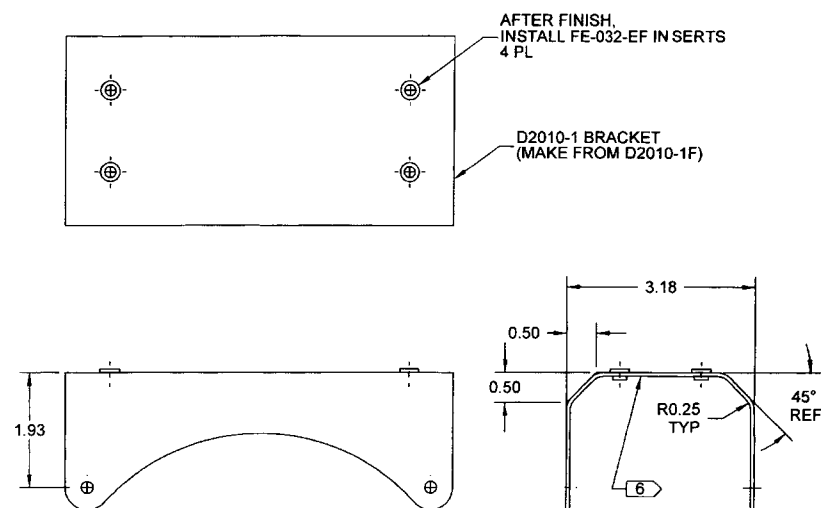
2

1

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



**D2010-1F FLAT PATTERN**



**D2010-101 MIRROR BRACKET**

**NOTES:**

- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDETEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: 0.23 lbs

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MFG. APPR.	AP	D2010	SHEET 2 OF 4
APPROVED	AP	TITLE	SCALE
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08-06-10





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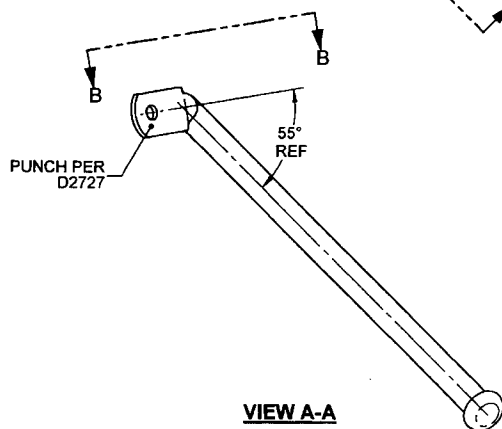
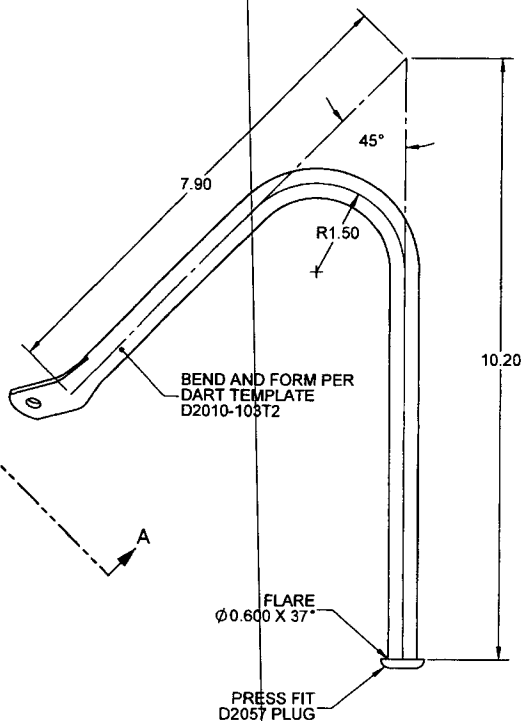
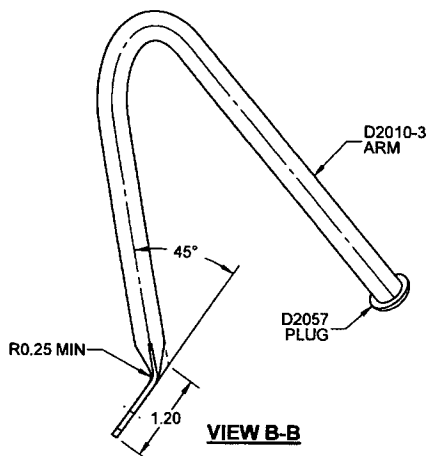
4

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1

QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



RELEASED  
08-06 R.114

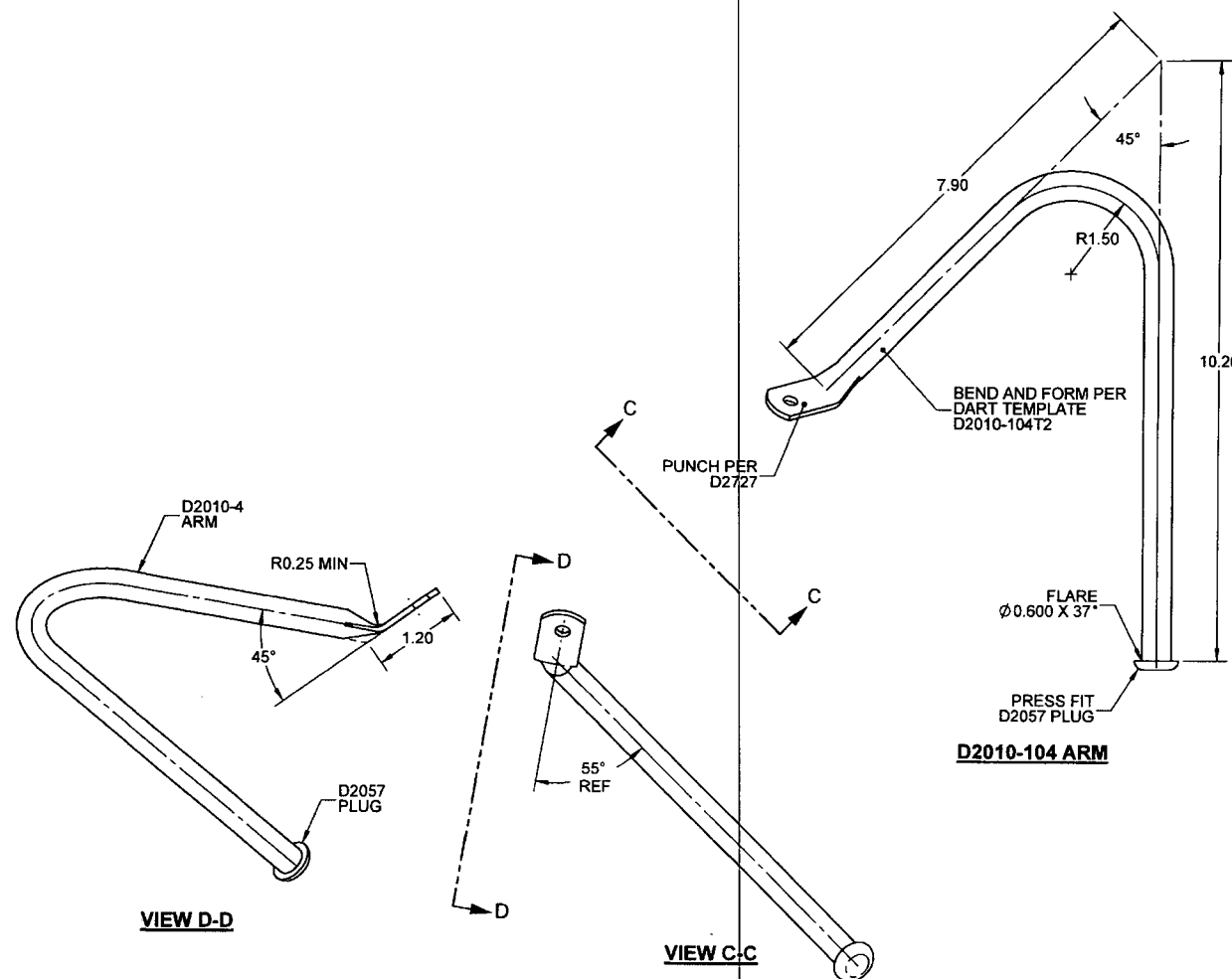
# NOTES:

- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049)  $\Delta$
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

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QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG



**D2010-104 ARM**

**NOTES:**

- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING, Ø 0.500 X 0.049 WALL (REF DART SPEC M304TR0.500W.049)  $\Delta$
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.34 lbs

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